

April-17-14 11:32:11 AM

Item ID: D4928-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut

Start Date: 21/04/2014 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 23/04/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4928	Rev A	

100		0.00	
100	DOOSAN LATHE		DAS 40 9-89
Doosan	Memo	0.00	4 0
Doosan Lathe	1- Turn as per Folio FB244		
	Rev: <u>NA</u> & Dwg D4928 Rev: <u>A</u>		14/04/14

2- Deburr

110	QC2- Inspect parts off machine FAI/FAIB	0.00	
110			DAS 40
QC	Memo	0.00	<u>4</u> <u>Ø</u> <u> </u> <u>9-89</u>
Quality Control			14/04/11

Work Order ID 116554

116554

Page 3

April-17-14 11:32:11 AM

Item ID: D4928-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 21/04/2014 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 23/04/2014 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 14/4/23				4			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: ST/A Memo	0.00 ST/27 0.00				4X		14-4-23	DAS 28 9-89
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						14/4/24	

14-4-24

Picklist Print

April-17-14 11:32:10 AM

Page 1

Work Order ID: 116554

116554

Parent Item: D4928-1

D4928-1

Parent Item Name: Strut

Start Date: 21/04/2014

Required Date: 23/04/2014

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-04-17 JLM VERIFIED BY

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M174PH-H900R0.750

Purchased

No

f

68.4958

2

DAS

M174PH-H900R0 750

**

14/04/14 40 9-89

17-4 SS H900 ROUND BAR 0.750"

Location

Loc Qty

Loc Code

MAT031

68.4958

M127334

3.8

→ M128314

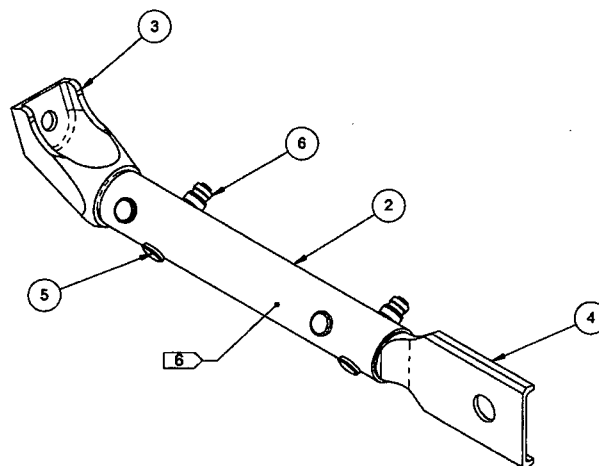
40.3

M128809

24.3958

2.1

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4928-041	LEG ASSEMBLY
2	1	D4928-1	STRUT
3	1	D4883-3	END FITTING
4	1	D4884-3	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



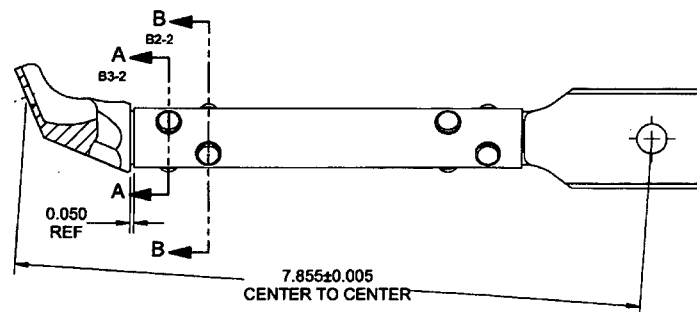
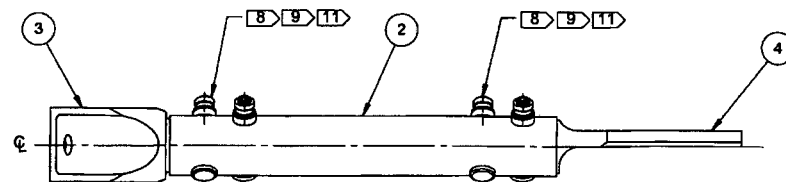
D4928-041 LEG ASSEMBLY

NOTES:

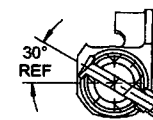
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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs
- 8) ALIGN PILOT HOLES IN D4928-1 WITH PILOT HOLES IN D4883-3 & D4884-3.
- 9) DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
- 10) REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9970
- 11) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 12) ASSEMBLE PER DART TOOL DT9970
- 13) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

RELEASE
2013-12-12
WAP

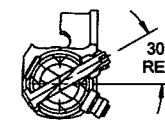
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REV.	DESCRIPTION			BY	DATE
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DRAWN	RF			SHEET 1 OF 3	
CHECKED	DC	DRAWING NO. D4928		SCALE	
MFG. APPR.	JLM	TITLE		NTS	
APPROVED	HS	LEG ASSEMBLY			
DE APPR.	DS				
DATE	13.12.10			COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4928-041 LEG ASSEMBLY
AUXILIARY VIEW



SECTION A-A C7-2
2 PL

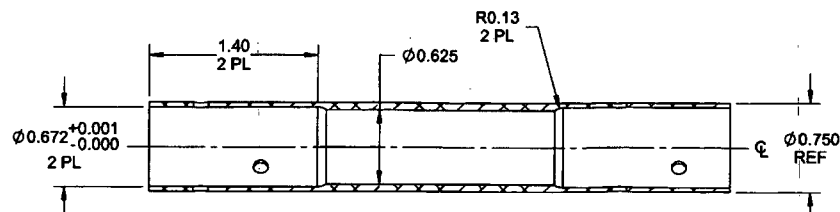


SECTION B-B C7-2
2 PL

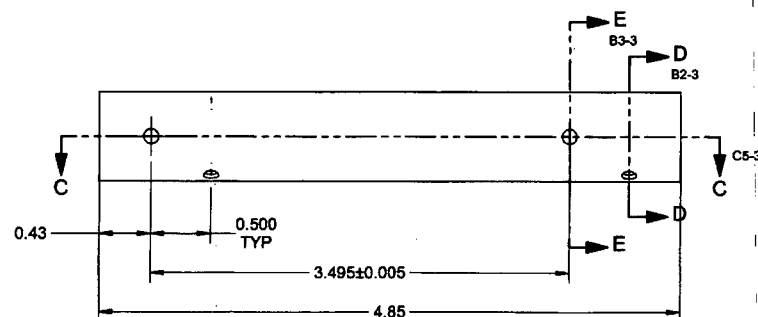
RELEASED
2013-12-12

APPROVED

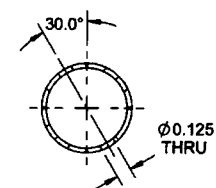
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DRAWN	RF		
CHECKED	DC	DRAWING NO. D4928	REV. A
MFG. APPR.	JLM	SHEET 2 OF 3	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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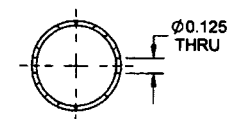
SECTION C-C B4-3



D4928-1 STRUT



SECTION D-D C4-3
2 PL



SECTION E-E C4-3
2 PL

NOTES:

- 1) MATERIAL: 17-4 PH /S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5843/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4928	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
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RELEASE
2013-12-12

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

Page: 1 of 1

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO19566	Customer: Cash Sale	Dept: NDT YUL	68-6	Reference: 23883
Descr:	PN: DART AEROSPACE	S/N:	12	Qty: 1
Make:	Model:	Reg:	14/14/03	A/C S/N:
TSN: 0	CSN: 0	TSO: 0		
Task: UNSCHEDULED				Sequence: 1

Work Required:

CARRY OUT NDT ON THE FOLLOWING ITEMS:

① STUD, ITEM ID D3691-1 QTY 8 WO 112605

② STRUT, ITEM ID D4928-1 QTY 4 WO 116554

Action Taken:

Date:

Initial/Stamp:

LIQUID PENETRANT INSPECTION CARRIED
OUT IAW ASTM E1417-M13 ON FOLLOWING
ITEMS:

① D3691-1, WO 112605 =

22 APR 14



② D4928-1, WO 116554 =

22 APR 14



Description	Location	P/N	Qty	Batch	S/N Off	S/N On
PENETRANT:	ARDEX	970 P2SE		TA010484		
BLACK LIGHT:	M 20189					

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 53-89	Date: 22 APR 2014
Name: GARY SMITH		

SKYM002-1 REV 3 Apr/12